

Work Order ID 60464

July 12, 2010 8:30:38 AM



Page 1

Item ID: D3913-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Base Assembly. 350

Start Date: 7/12/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/20/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D3913

A

100



Large Fab

- Large Fab

Weld per dwg A/R S.S. rod Batch: H108775 0.00
Large Fab

Memo 0.00

1- assemble ribs , weld as per dwg D3913 using DT9610A
inspect before welding mesh
2- tack weld mesh on basket as per dwg D3913 and trim mesh to fit if necessary
and trim to clear fasteners holes on the ends
3- weld hinge (3) and Mounting brackets as per dwg D3913
take lid to locate hinge and bracket

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds 0.00

Memo 0.00

① PD 10.07.15

CP 10.07.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Item ID: D3913-041

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Setup Start

Stop

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Required Date: 7/20/10 Req'd Qty: 1.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

~~QC~~ Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

51067116

(XU)

P12 →

130



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

Memo

0.00

1- Plug holes and mask only interior of hinge (3) prior to powder coat

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

***** 2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:30 AM
400 OF
12:00 AM
12:15
400 OF
12:45

M114841

M.K. 10/07/20

(1X)

W/O: 60464

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/7/16	#120	perm. change change to QC inspection		007.22			S 10/07/16

Part No: D3913-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 60464

July 12, 2010 8:30:45 AM

Page 3

Item ID: D3913-041

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Revision ID:

Item Name: Long Basket Base Assembly, 350

Start Date: 7/12/10 Start Qty: 1.00

Required Date: 7/20/10 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Sp 10/07/21

①

150

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

Pick Kit

Sp 10/07/21

①

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sp 10/07/21

④

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Page 4

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Customer:

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

used on w/o 60462

Memo

0.00

Packaging

D4030-041

SS 1060761 0

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/22
mf

10-7-21

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Picklist Print

July 12, 2010 8:30:33 AM

Page 1

Work Order ID: 60464

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly. 350



Start Date: 7/12/10

Required Date: 7/20/10

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-10A 		Purchased	No			150	Each	94.0000	6	6			
Bolt													

Location

Loc Qty

Loc Code

ST351

94

115016

94

AN960JD8

NAS1149DN832
J

Purchased

No

150

Each

0.0000

2

2

Washer

D2581

Manufactured

No

100

Each

18.0000

2

2

Mounting Bracket

Location

Loc Qty

Loc Code

WA

18

46086

2

51745

1

57185

1

59265

14

D2931

Manufactured

No

150

Each

816.0000

2

2

Bumper

Location

Loc Qty

Loc Code

ST504

816

46064

816

6 Sh 6/02/20

10/07/20

PD 10.07.12

2

2 Sh 10/02/20

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July 12, 2010 8:30:34 AM

Page 2

Work Order ID: 60464

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 7/12/10

Required Date: 7/20/10

Start Qty: 1.00

Required Qty: 1.00

D3913-1



Rib

Manufactured No

100 Each

4.0000



PD 10.07.12

Location

Loc Qty

Loc Code

WA

4

59337

1

59842

3

D3913-15



Wide Handle Plate

Manufactured No

100 Each

6.0000



PD 10.07.12

Location

Loc Qty

Loc Code

WA

6

58586

3

60324

3

D3913-3



Rib

Manufactured No

100 Each

5.0000



PD 10.07.12

Location

Loc Qty

Loc Code

WA

5

59338

2

60323

3

D3913-7



Rib

Manufactured No

100 Each

11.0000



PD 10.07.12

Location

Loc Qty

Loc Code

WA

11

59339

2

59743

3

60263

6

July 12, 2010 8:30:34 AM

Shop Packet Print

Page 2

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July 12, 2010 8:30:34 AM

Page 3

Work Order ID: 60464

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 7/12/10

Required Date: 7/20/10

Start Qty: 1.00

Required Qty: 1.00

D3913-9

 Hinge Rib


Manufactured No 100 Each 5.0000 1 1
 PD 10.02.12


Location Loc Qty Loc Code

WA 5

59731 2

60322 3

D3916-041

 Rib Assembly

Manufactured No 100 Each 4.0000 2 2
 PD 10.07.12

Location Loc Qty Loc Code

WA 4

59732 4

D3916-5

 Light Rib


Manufactured No 100 Each 9.0000 3 3
 PD 10.07.12


Location Loc Qty Loc Code

WA 9

57023 2

59535 7

D4016-1

 Hinge Half, Base

Manufactured No 100 Each 9.0000 3 3
 PD 10.02.12

Location Loc Qty Loc Code

WA 9

59983 9

July 12, 2010 8:30:34 AM

Shop Packet Print

Page 3

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July 12, 2010 8:30:35 AM

Page 4

Work Order ID: 60464

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 7/12/10

Required Date: 7/20/10

Start Qty: 1.00

Required Qty: 1.00

D4017-7



Rib

Manufactured No

100 Each

5.0000



PD 10.07.12

Location

Loc Qty

Loc Code

WA

5

58929

2

59836

3

D4017-9



Rib

Manufactured No

100 Each

10.0000



PD 10.07.12

Location

Loc Qty

Loc Code

WA

10

59538

4

59984

6

D4020-1



Mesh (350 Basket Long, Base)

Manufactured No

100 Each

4.0000



PD 10.07.14

Location

Loc Qty

Loc Code

WA

4

59555

1

59848

3

D4020-11



End Mesh, Basket

Manufactured No

100 Each

12.0000



PD 10.07.14

Location

Loc Qty

Loc Code

WA

12

58136

1

59413

5

59942

6

(2)

July 12, 2010 8:30:35 AM

Shop Packet Print

Page 4

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July 12, 2010 8:30:35 AM

Page 5

Work Order ID: 60464

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 7/12/10

Required Date: 7/20/10

Start Qty: 1.00

Required Qty: 1.00

D4021-1

Manufactured No

100

Each

18.0000

3

3



Handle Plate

Location

Loc Qty

Loc Code

ST109

5

57086

5

WA

13

59746

4

60183

9



PD 10.01.12

D4021-5

Manufactured No

150

Each

3.0000

2

2



Blanking Plate

Location

Loc Qty

Loc Code

ST111

3

59096

3

B 62717

①

SO 10/07/12

D4034-041

Manufactured No

100

Each

3.0000

1

1



Aft Upper Rib Assembly

Location

Loc Qty

Loc Code

WA

3

58729

1

59747

2

①

D4034-043

Manufactured No

100

Each

3.0000

1

1



Fwd Upper Rib Assembly

Location

Loc Qty

Loc Code

WA

3

59748

3

①

PD 10.01.12

July 12, 2010 8:30:36 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

July 12, 2010 8:30:36 AM

Page 6

Work Order ID: 60464

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 7/12/10

Required Date: 7/20/10

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W3

Purchased

No

150

Each

1,631.000

2

2



Cherry Rivets

Location

Loc Qty

Loc Code

ST321

1631

106375

3

107939

822

111636

806

SB 10/07/20
2
6

MS21042L3

Purchased

No

150

Each

2,708.000

6

6



Nut

Location

Loc Qty

Loc Code

ST300

2708

114523

232

114718

476

114784

2000

SB 10/07/20
6
12

NAS1149F0332P

Purchased

No

150

Each

691.0000

12

12



WASHER

Location

Loc Qty

Loc Code

ST275

691

18057

691

SB 10/07/20
12

July 12, 2010 8:30:36 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

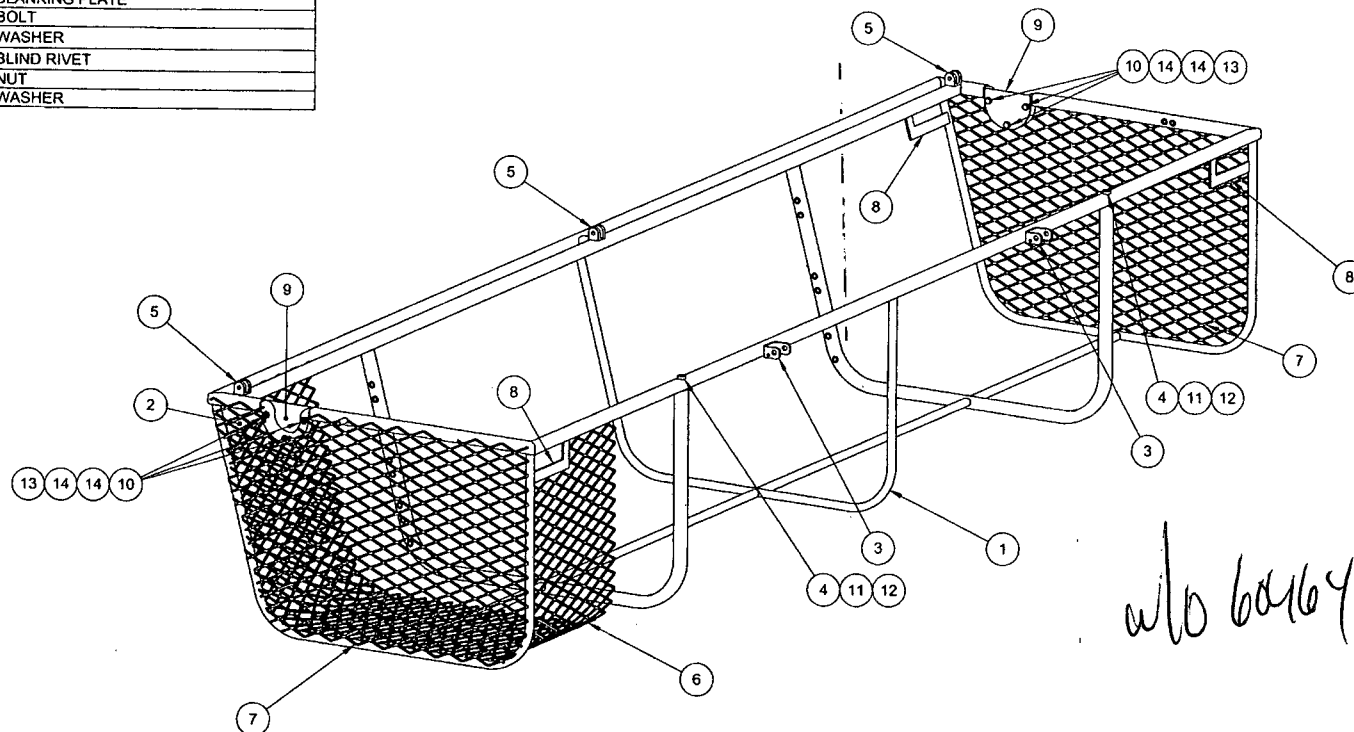
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ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2010-03-22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

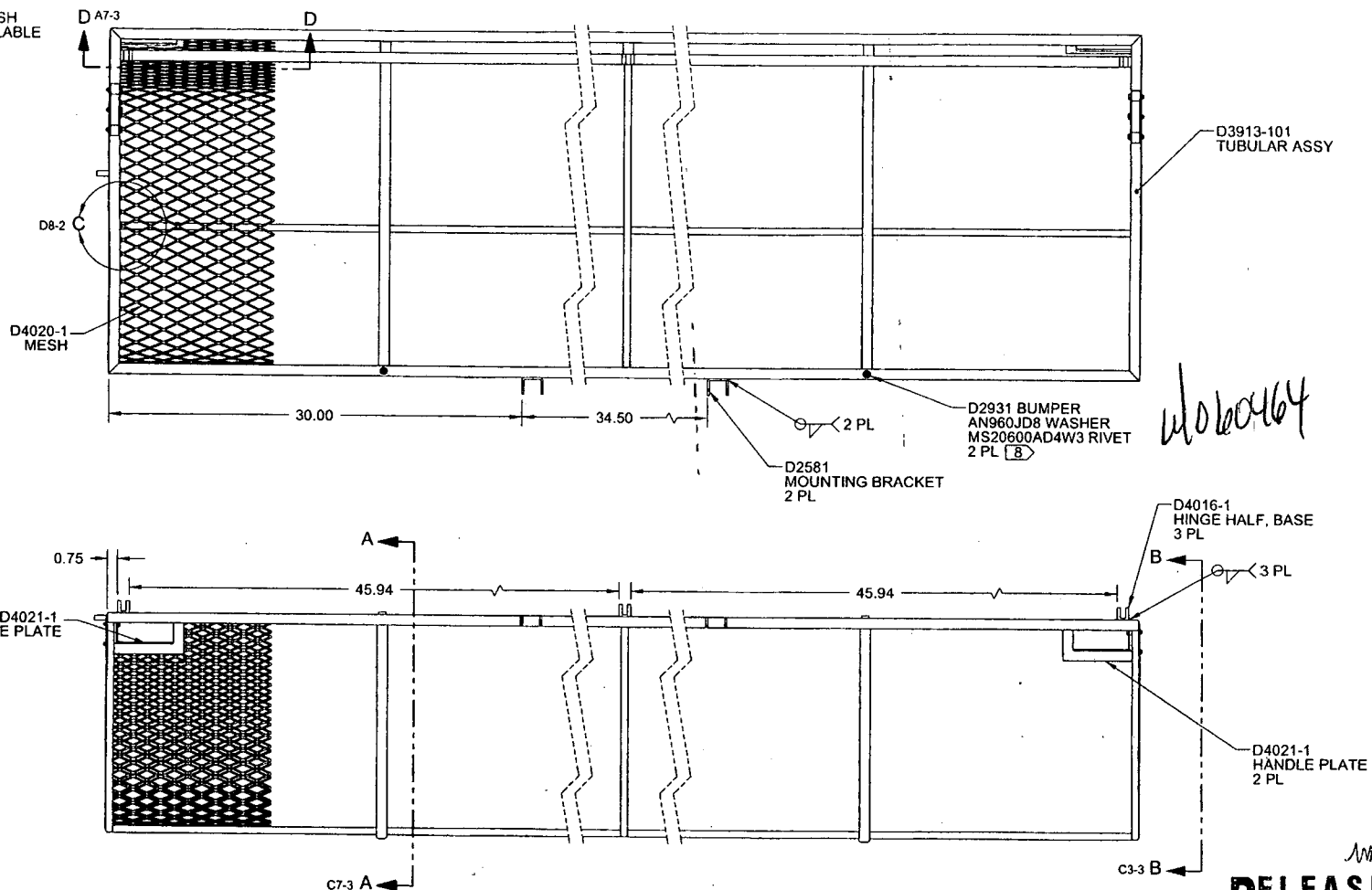
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TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

DETAIL C D7-2



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-03-27

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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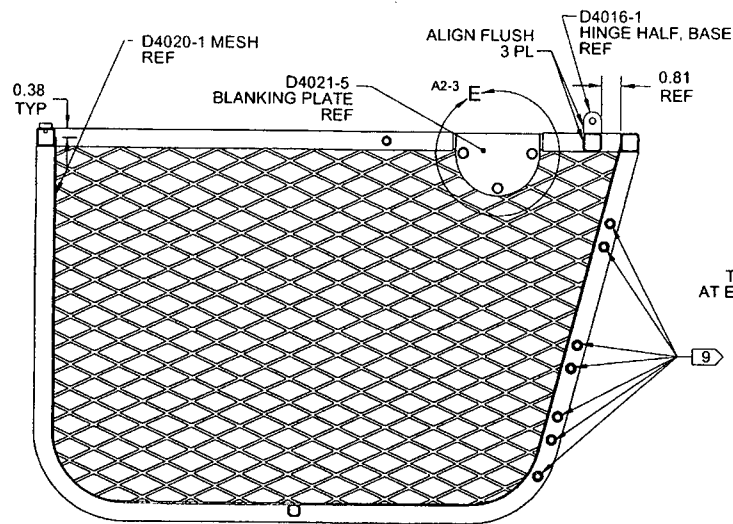
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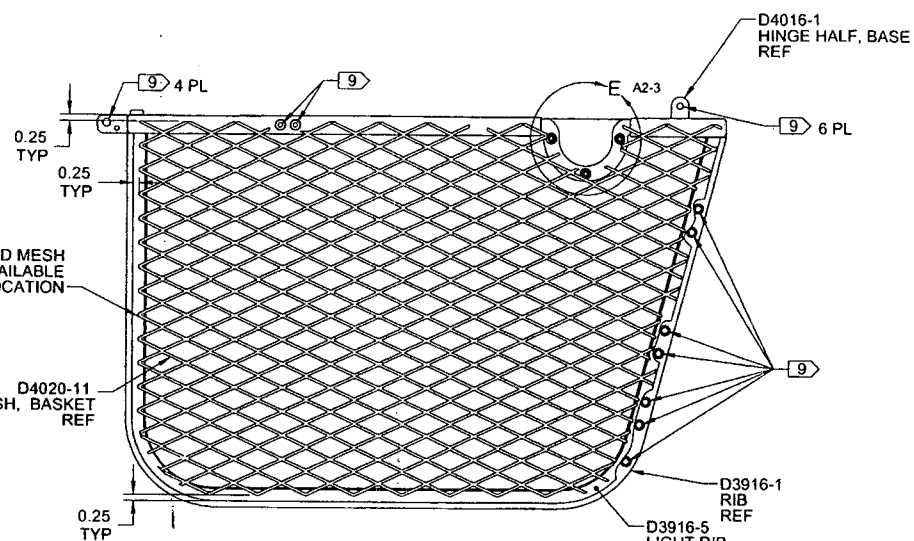
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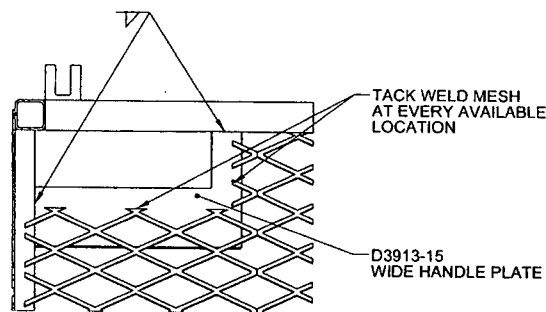
NOTE: Date & initial all entries



SECTION A-A A5-2



VIEW B-B A2-2



SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES

8 D4021-5
BLANKING PLATE

8 AN3-10A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
3 PL

TRIM MESH LOCALLY
Ø0.50 - Ø0.60
TO CLEAR FASTENERS

DETAIL E D2-3
D6-3

RELEASED
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. A
MFG. APPR.	JS	D3913	SHEET 3 OF 6
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	LONG BASKET BASE ASSY (350)	NTS
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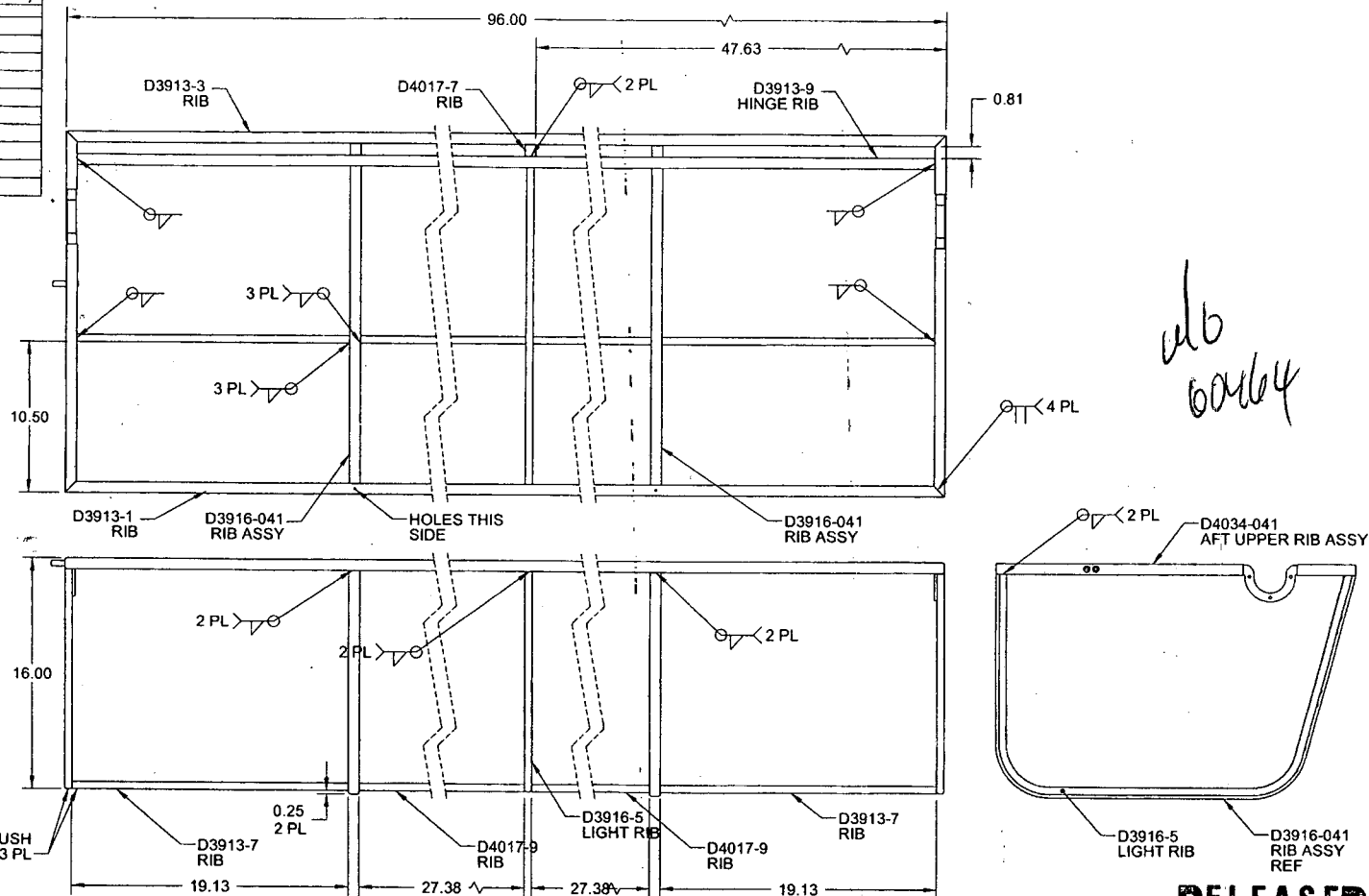
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JRH		
CHECKED	A	DRAWING NO.	REV. A
MFG. APPR.	A	D3913	SHEET 4 OF 6
APPROVED	A	TITLE	SCALE
DE APPR.	A	LONG BASKET BASE ASSY (350)	NTS
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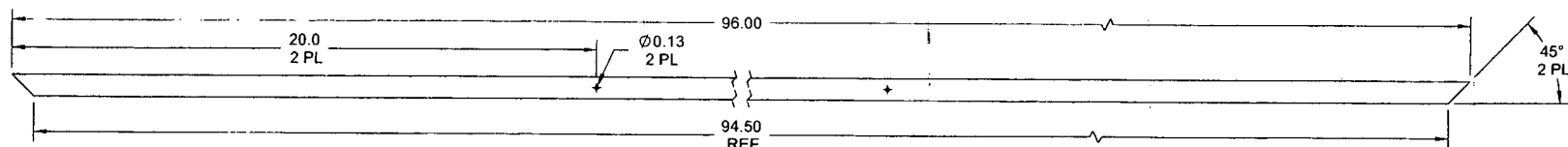
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

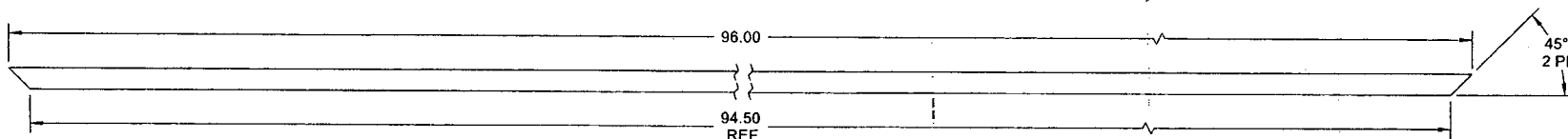
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

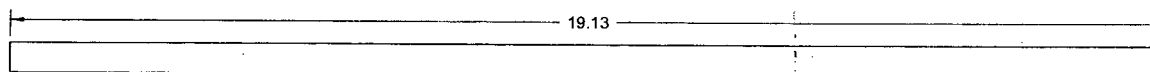
NOTE: Date & initial all entries



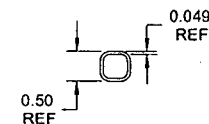
D3913-1 RIB



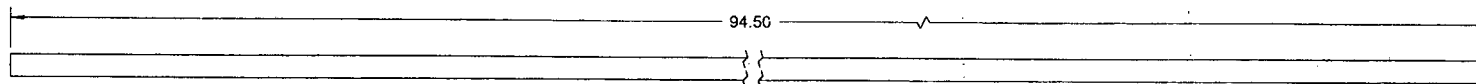
D3913-3 RIB



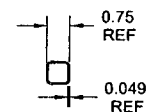
D3913-7 RIB



*WLB
bonyb4*



D3913-9 HINGE RIB



NOTES:

1) MATERIAL -1, -3, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: SEE ASSEMBLED WEIGHTS

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DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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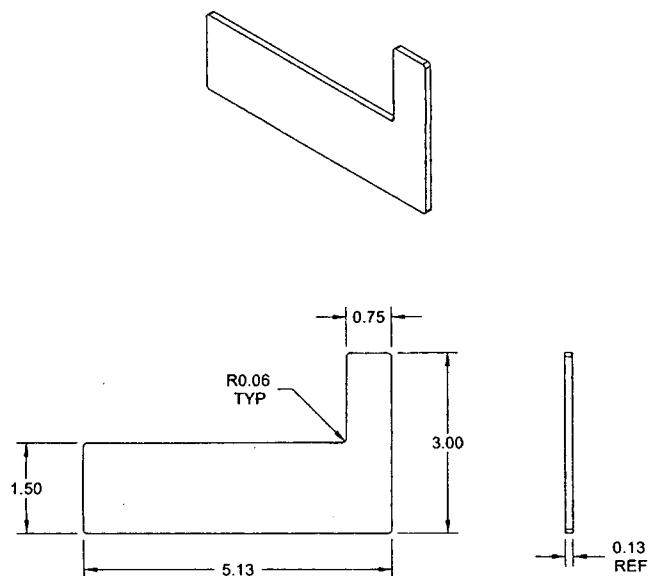
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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2010-03-22

*also
bobby*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries